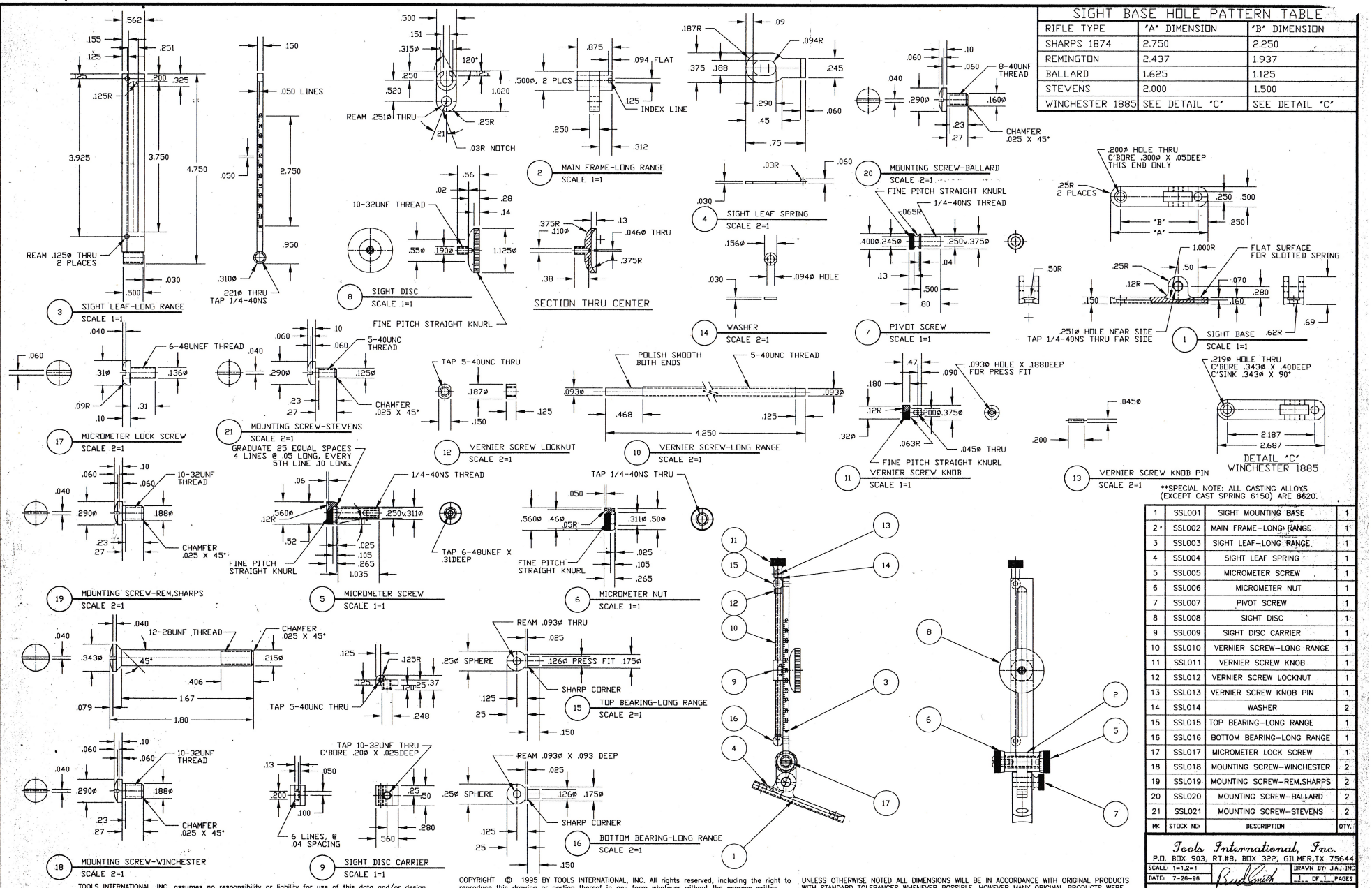
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8 SIGHT DISC SCALE 1=1
2 MAIN FRAME-LONG RANGE SCALE 1=1
4 SIGHT LEAF SPRING SCALE 2=1
20 MOUNTING SCREW-BALLARD SCALE 2=1
1 SIGHT BASE SCALE 1=1
17 MICROMETER LOCK SCREW SCALE 2=1
21 MOUNTING SCREW-STEVENS SCALE 2=1
12 VERNIER SCREW LOCKNUT SCALE 2=1
10 VERNIER SCREW-LONG RANGE SCALE 2=1
14 WASHER SCALE 2=1
7 PIVOT SCREW SCALE 1=1
11 VERNIER SCREW KNOB SCALE 1=1
13 VERNIER SCREW KNOB PIN SCALE 2=1
19 MOUNTING SCREW-REM,SHARPS SCALE 2=1
5 MICROMETER SCREW SCALE 1=1
6 MICROMETER NUT SCALE 1=1
15 TOP BEARING-LONG RANGE SCALE 2=1
16 BOTTOM BEARING-LONG RANGE SCALE 2=1
18 MOUNTING SCREW-WINCHESTER SCALE 2=1
9 SIGHT DISC CARRIER SCALE 1=1
SECTION THRU CENTER
DETAIL 'C' WINCHESTER 1885
REAM .125ø THRU 2 PLACES
.050 LINES
.221ø THRU TAP 1/4-40NS
REAM .251ø THRU
.03R NOTCH
10-32UNF THREAD
FINE PITCH STRAIGHT KNURL
INDEX LINE
SHARP CORNER
.126ø PRESS FIT .175ø
REAM .093ø THRU
REAM .093ø X .093 DEEP
TAP 5-40UNC THRU
TAP 6-48UNEF X .31DEEP
TAP 1/4-40NS THRU
TAP 10-32UNF THRU C'BORE .20ø X .025DEEP
6 LINES, @ .04 SPACING
GRADUATE 25 EQUAL SPACES 4 LINES @ .05 LONG, EVERY 5TH LINE .10 LONG.
FINE PITCH STRAIGHT KNURL
POLISH SMOOTH BOTH ENDS
5-40UNC THREAD
1/4-40NS THREAD
.093ø HOLE X .188DEEP FOR PRESS FIT
.045ø THRU
.200ø HOLE THRU C'BORE .300ø X .05DEEP THIS END ONLY
.251ø HOLE NEAR SIDE TAP 1/4-40NS THRU FAR SIDE
FLAT SURFACE FOR SLOTTED SPRING
.219ø HOLE THRU C'BORE .343ø X .40DEEP C'SINK .343ø X 90°
.094ø HOLE
CHAMFER .025 X 45°
8-40UNF THREAD
1/4-40NS THREAD
4.250
3.925
3.750
4.750
2.750
.950
1.020
1.125ø
2.187
2.687

SIGHT BASE HOLE PATTERN TABLE		
RIFLE TYPE	'A' DIMENSION	'B' DIMENSION
SHARPS 1874	2.750	2.250
REMINGTON	2.437	1.937
BALLARD	1.625	1.125
STEVENS	2.000	1.500
WINCHESTER 1885	SEE DETAIL 'C'	SEE DETAIL 'C'

**SPECIAL NOTE: ALL CASTING ALLOYS (EXCEPT CAST SPRING 6150) ARE 8620.

MK	STOCK NO	DESCRIPTION	QTY.
1	SSL001	SIGHT MOUNTING BASE	1
2 *	SSL002	MAIN FRAME-LONG RANGE	1
3	SSL003	SIGHT LEAF-LONG RANGE	1
4	SSL004	SIGHT LEAF SPRING	1
5	SSL005	MICROMETER SCREW	1
6	SSL006	MICROMETER NUT	1
7	SSL007	PIVOT SCREW	1
8	SSL008	SIGHT DISC	1
9	SSL009	SIGHT DISC CARRIER	1
10	SSL010	VERNIER SCREW-LONG RANGE	1
11	SSL011	VERNIER SCREW KNOB	1
12	SSL012	VERNIER SCREW LOCKNUT	1
13	SSL013	VERNIER SCREW KNOB PIN	1
14	SSL014	WASHER	2
15	SSL015	TOP BEARING-LONG RANGE	1
16	SSL016	BOTTOM BEARING-LONG RANGE	1
17	SSL017	MICROMETER LOCK SCREW	1
18	SSL018	MOUNTING SCREW-WINCHESTER	2
19	SSL019	MOUNTING SCREW-REM,SHARPS	2
20	SSL020	MOUNTING SCREW-BALLARD	2
21	SSL021	MOUNTING SCREW-STEVENS	2

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SOULE TANG SIGHT

LONG RANGE | DRAWING NUMBER SSL-1

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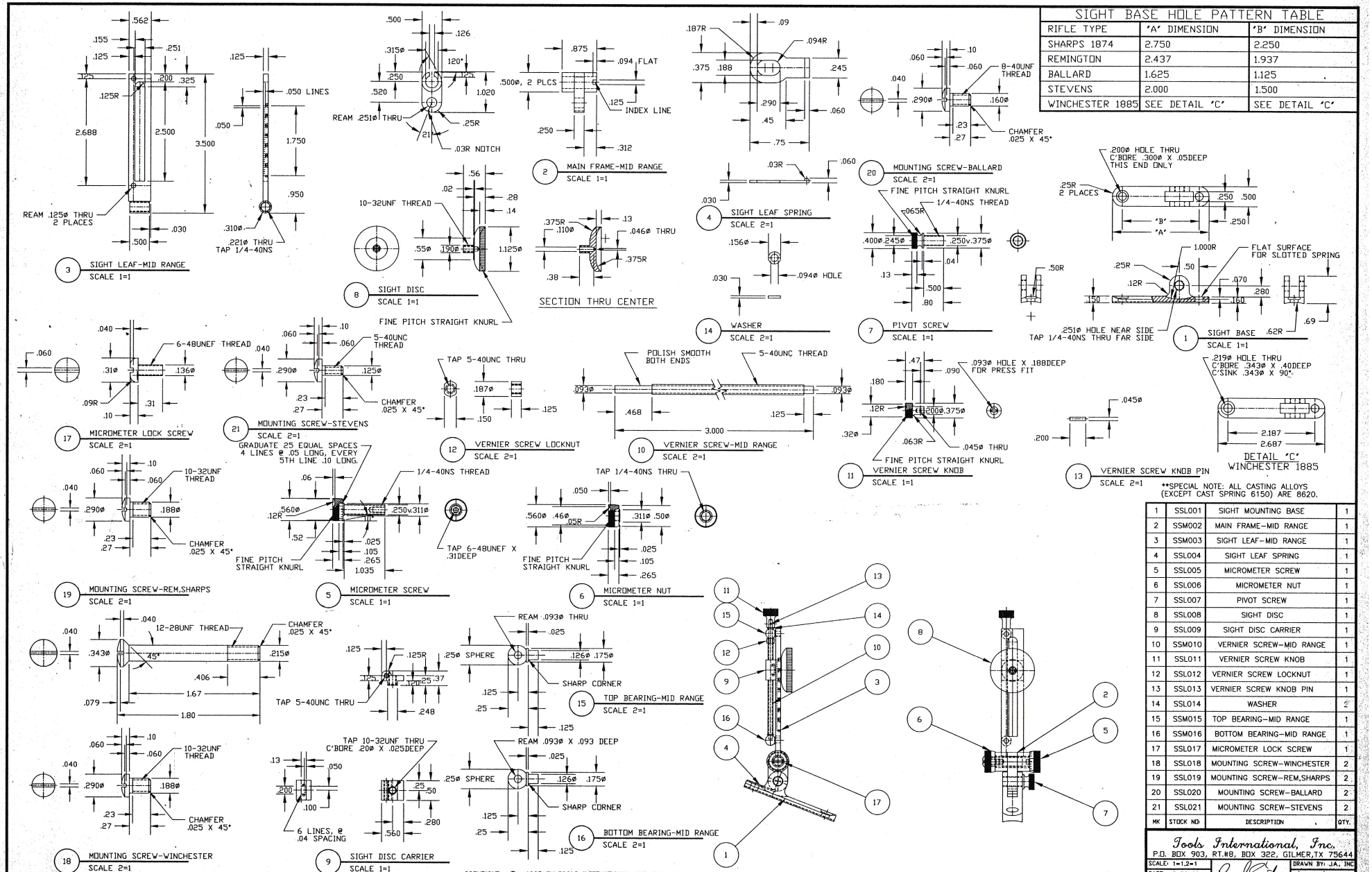
3 SIGHT LEAF-MID RANGE SCALE 1=1
REAM .125ø THRU 2 PLACES
8 SIGHT DISC SCALE 1=1
FINE PITCH STRAIGHT KNURL
2 MAIN FRAME-MID RANGE SCALE 1=1
REAM .251ø THRU
.03R NOTCH
.094 FLAT
INDEX LINE
SECTION THRU CENTER
4 SIGHT LEAF SPRING SCALE 2=1
14 WASHER SCALE 2=1
20 MOUNTING SCREW-BALLARD SCALE 2=1
FINE PITCH STRAIGHT KNURL
1/4-40NS THREAD
7 PIVOT SCREW SCALE 1=1
.200ø HOLE THRU C'BORE .300ø X .05DEEP THIS END ONLY
2 PLACES
'B'
'A'
FLAT SURFACE FOR SLOTTED SPRING
.251ø HOLE NEAR SIDE TAP 1/4-40NS THRU FAR SIDE
1 SIGHT BASE SCALE 1=1
.219ø HOLE THRU C'BORE .343ø X .40DEEP C'SINK .343ø X 90°
DETAIL 'C' WINCHESTER 1885
13 VERNIER SCREW KNOB PIN SCALE 2=1
**SPECIAL NOTE: ALL CASTING ALLOYS (EXCEPT CAST SPRING 6150) ARE 8620.
17 MICROMETER LOCK SCREW SCALE 2=1
6-48UNEF THREAD
21 MOUNTING SCREW-STEVENS SCALE 2=1
GRADUATE 25 EQUAL SPACES 4 LINES @ .05 LONG, EVERY 5TH LINE .10 LONG.
5-40UNC THREAD
CHAMFER .025 X 45°
12 VERNIER SCREW LOCKNUT SCALE 2=1
TAP 5-40UNC THRU
10 VERNIER SCREW-MID RANGE SCALE 2=1
POLISH SMOOTH BOTH ENDS
11 VERNIER SCREW KNOB SCALE 1=1
.093ø HOLE X .188DEEP FOR PRESS FIT
FINE PITCH STRAIGHT KNURL
19 MOUNTING SCREW-REM,SHARPS SCALE 2=1
10-32UNF THREAD
12-28UNF THREAD
5 MICROMETER SCREW SCALE 1=1
1/4-40NS THREAD
FINE PITCH STRAIGHT KNURL
TAP 6-48UNEF X .31DEEP
6 MICROMETER NUT SCALE 1=1
TAP 1/4-40NS THRU
FINE PITCH STRAIGHT KNURL
TAP 5-40UNC THRU
15 TOP BEARING-MID RANGE SCALE 2=1
REAM .093ø THRU
SHARP CORNER
16 BOTTOM BEARING-MID RANGE SCALE 2=1
REAM .093ø X .093 DEEP
SHARP CORNER
18 MOUNTING SCREW-WINCHESTER SCALE 2=1
9 SIGHT DISC CARRIER SCALE 1=1
TAP 10-32UNF THRU C'BORE .20ø X .025DEEP
6 LINES, @ .04 SPACING

SIGHT BASE HOLE PATTERN TABLE		
RIFLE TYPE	'A' DIMENSION	'B' DIMENSION
SHARPS 1874	2.750	2.250
REMINGTON	2.437	1.937
BALLARD	1.625	1.125
STEVENS	2.000	1.500
WINCHESTER 1885	SEE DETAIL 'C'	SEE DETAIL 'C'

MK	STOCK NO	DESCRIPTION	QTY.
1	SSL001	SIGHT MOUNTING BASE	1
2	SSM002	MAIN FRAME-MID RANGE	1
3	SSM003	SIGHT LEAF-MID RANGE	1
4	SSL004	SIGHT LEAF SPRING	1
5	SSL005	MICROMETER SCREW	1
6	SSL006	MICROMETER NUT	1
7	SSL007	PIVOT SCREW	1
8	SSL008	SIGHT DISC	1
9	SSL009	SIGHT DISC CARRIER	1
10	SSM010	VERNIER SCREW-MID RANGE	1
11	SSL011	VERNIER SCREW KNOB	1
12	SSL012	VERNIER SCREW LOCKNUT	1
13	SSL013	VERNIER SCREW KNOB PIN	1
14	SSL014	WASHER	2
15	SSM015	TOP BEARING-MID RANGE	1
16	SSM016	BOTTOM BEARING-MID RANGE	1
17	SSL017	MICROMETER LOCK SCREW	1
18	SSL018	MOUNTING SCREW-WINCHESTER	2
19	SSL019	MOUNTING SCREW-REM,SHARPS	2
20	SSL020	MOUNTING SCREW-BALLARD	2
21	SSL021	MOUNTING SCREW-STEVENS	2

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SOULE TANG SIGHT

MID RANGE

DRAWING NUMBER SSL-2

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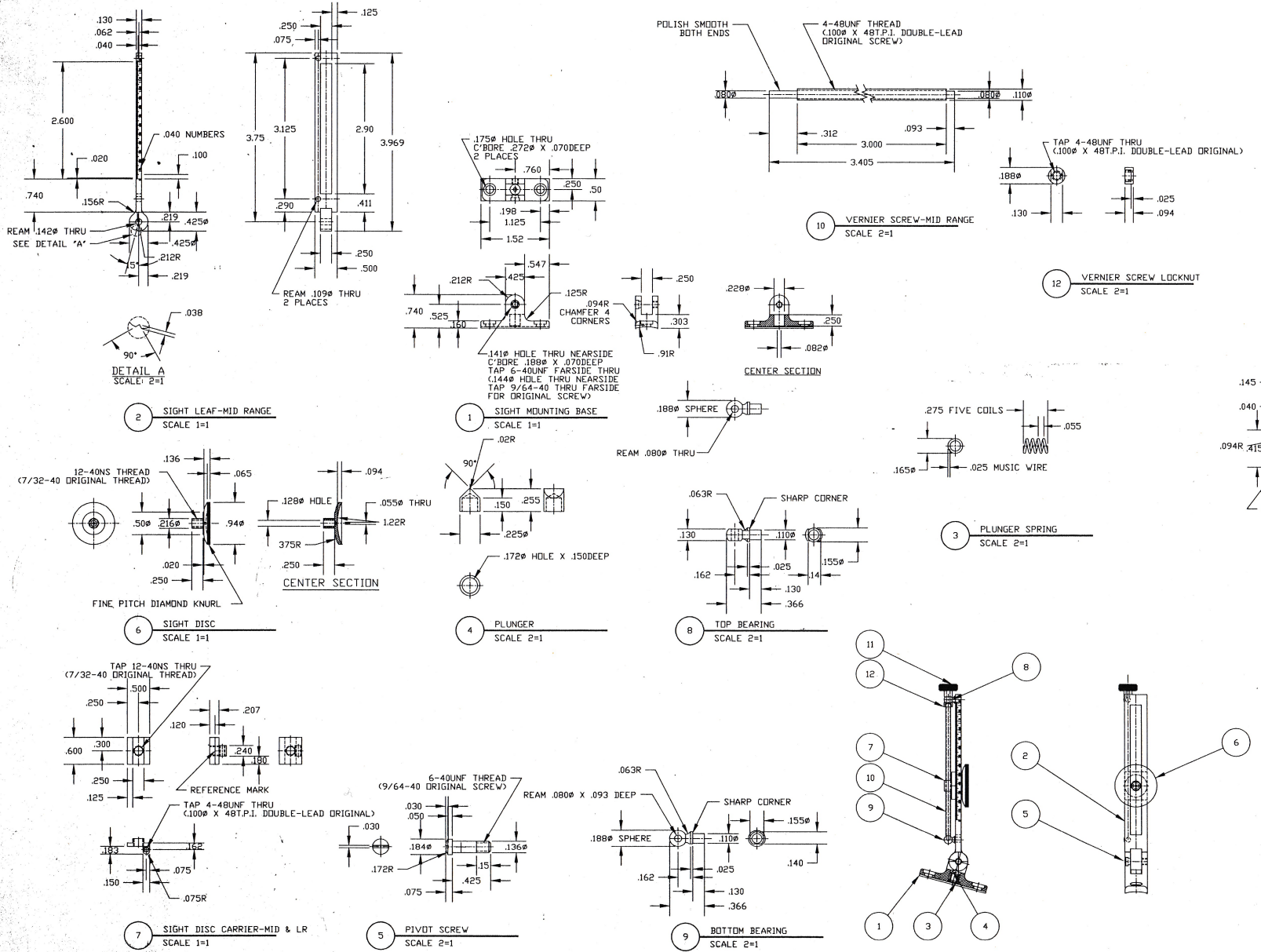

**SPECIAL NOTE: ALL CASTING ALLOYS (EXCEPT CAST SPRING 6150) ARE 8620.

MK	STOCK NO	DESCRIPTION	QTY.
1	BTS009	SIGHT MOUNTING BASE	1
2	BTS010	SIGHT LEAF-MID RANGE	1
3	BTS011	PLUNGER SPRING	1
4	BTS012	PLUNGER	1
5	BTS013	PIVOT SCREW	1
6	BTS006	SIGHT DISC	1
7	BTS014	SIGHT DISC CARRIER-MID & LR	1
8	BTS015	TOP BEARING	1
9	BTS016	BOTTOM BEARING	1
10	BTS017	VERNIER SCREW-MID RANGE	1
11	BTS018	VERNIER SCREW KNOB	1
12	BTS019	VERNIER SCREW LOCKNUT	1

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SCALE: 1=1.2=1
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SHEET 2 OF 3 PAGES

MID RANGE TANG SIGHT

BALLARD

DRAWING NUMBER BTS-2

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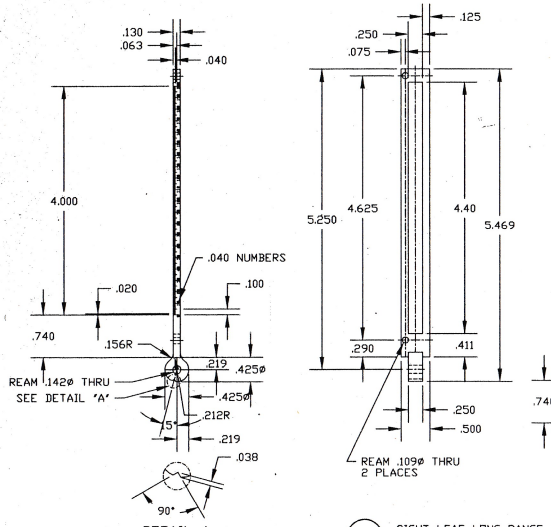
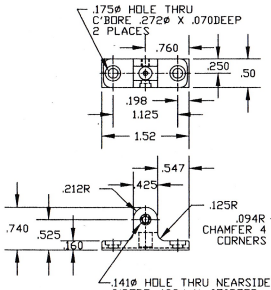
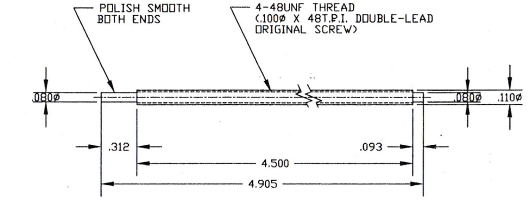


DETAIL A
SCALE: 2=1

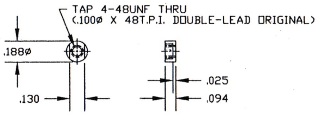
2 SIGHT LEAF-LONG RANGE
SCALE 1=1



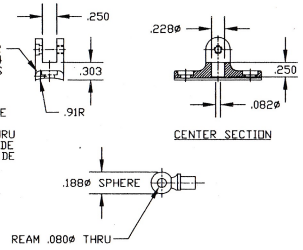
1 SIGHT MOUNTING BASE
SCALE 1=1

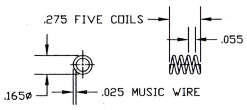


10 VERNIER SCREW-LONG RANGE
SCALE 2=1



12 VERNIER SCREW LOCKNUT
SCALE 2=1





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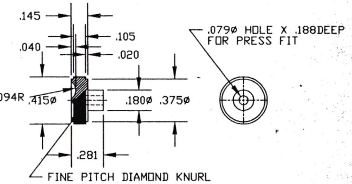
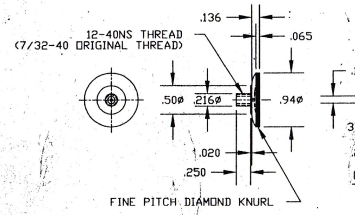
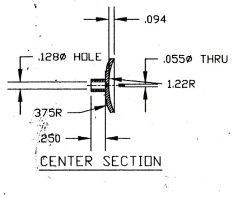
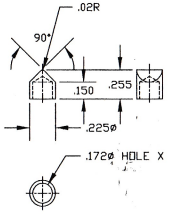


11 VERNIER SCREW KNOB
SCALE 2=1

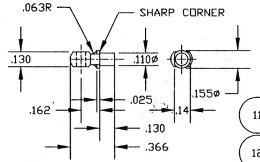




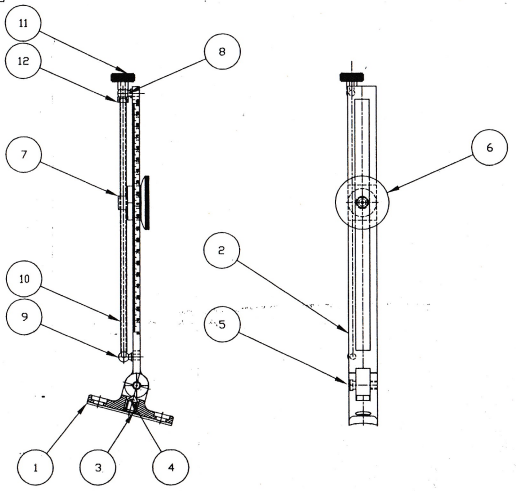
6 SIGHT DISC
SCALE 1=1

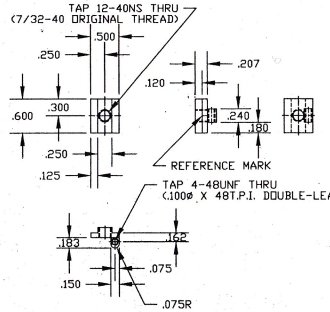


4 PLUNGER
SCALE 2=1

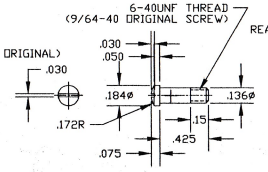


8 TOP BEARING
SCALE 2=1

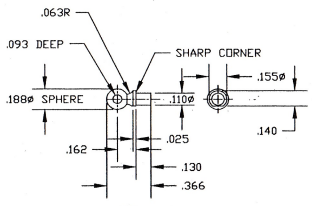




7 SIGHT DISC CARRIER-MID & LR
SCALE 1=1



5 PIVOT SCREW
SCALE 2=1



9 BOTTOM BEARING
SCALE 2=1

**SPECIAL NOTE: ALL CASTING ALLOYS (EXCEPT CAST SPRING 6150) ARE 8620.

1	BTS009	SIGHT MOUNTING BASE	1
2	BTS020	SIGHT LEAF-LONG RANGE	1
3	BTS011	PLUNGER SPRING	1
4	BTS012	PLUNGER	1
5	BTS013	PIVOT SCREW	1
6	BTS006	SIGHT DISC	1
7	BTS014	SIGHT DISC CARRIER-MID & LR	1
8	BTS015	TOP BEARING	1
9	BTS016	BOTTOM BEARING	1
10	BTS021	VERNIER SCREW-LONG RANGE	1
11	BTS018	VERNIER SCREW KNOB	1
12	BTS019	VERNIER SCREW LOCKNUT	1
MK	STOCK NO:	DESCRIPTION	QTY.

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LONG RANGE TANG SIGHT

BALLARD | DRAWING NUMBER BTS-3

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